

Date: Monday, 15/12/2008 2:01:40 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE
Job Number	: 44086		
Estimate Number	: 10316		
P.O. Number	:	Part Number	: D2680041
This Issue	: 15/12/2008 S.O. No. :	Drawing Number	: D2680 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 34599	Material	:
Written By	:	Due Date	: 22/12/2008 Qty: 50 Um: Each
Checked & Approved By	: <u>JLD 08.12.15</u>		
Comment	: Est: D 04.10.01 Added Steps 2-4, 7-8 KJ/JLM Est Rev:E Now on WaterJet 06-10-12 JLM est rev F QC5 after c'sink 07.07.05 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025 sheet 16GA
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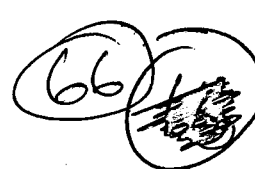
Comment: Qty.: 0.0138 sf(s)/Unit Total : 0.6878 sf(s)
 1010/1025/A21/6aA SHEET .063" thk
 Batch: 105706 IB 8-12-18

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2680
 Dwg Rev: B1
 Prog Rev: B1

IB 8-12-18



2-Deburr if necessary

EP 08/12/19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-12-18

65



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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08.12.29 (65)
counted.



Comment: SECOND CHECK

5.0	SMALL FAB 1.	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Deburr
 2-C'sink as per Dwg D2680

EP 09/01/15 (65)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2680-041 PAR #: N/A Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AS Date: 09.01.30
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>44086</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/12/22</u>	<u>2</u>	<u>1 piece hole are</u> <u>not round</u> <u>at the water jet</u> <u>R.C. Process / blow wts</u> <u>happen on occasion.</u>	<u>[Signature]</u>	<u>Scraps destroy</u> <u>no replace</u>	<u>EB</u> <u>08/12/29</u>	<u>[Signature]</u> <u>08-12-29</u>	<u>[Signature]</u>	<u>[Signature]</u> <u>08-12-22</u>

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 44086

Part Number: D2680041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50260115 counter
X65

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:25

OVEN TEMPERATURE:

480°

FINISH TIME:

1:55

FL 09/01/26

65

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-26

X65

9.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty

Part Number Description Batch

2

MS20426AD3-3

Rivet

M1563

09/01/28

10.0

MS21069L4

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty

Part Number

Description Batch

1

MS21069L4

Nut Plate

M18536

09/01/28

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D2680

09/01/28 65

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50260128 counter
X65

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 40

SS 09/01/28 x 65

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/29 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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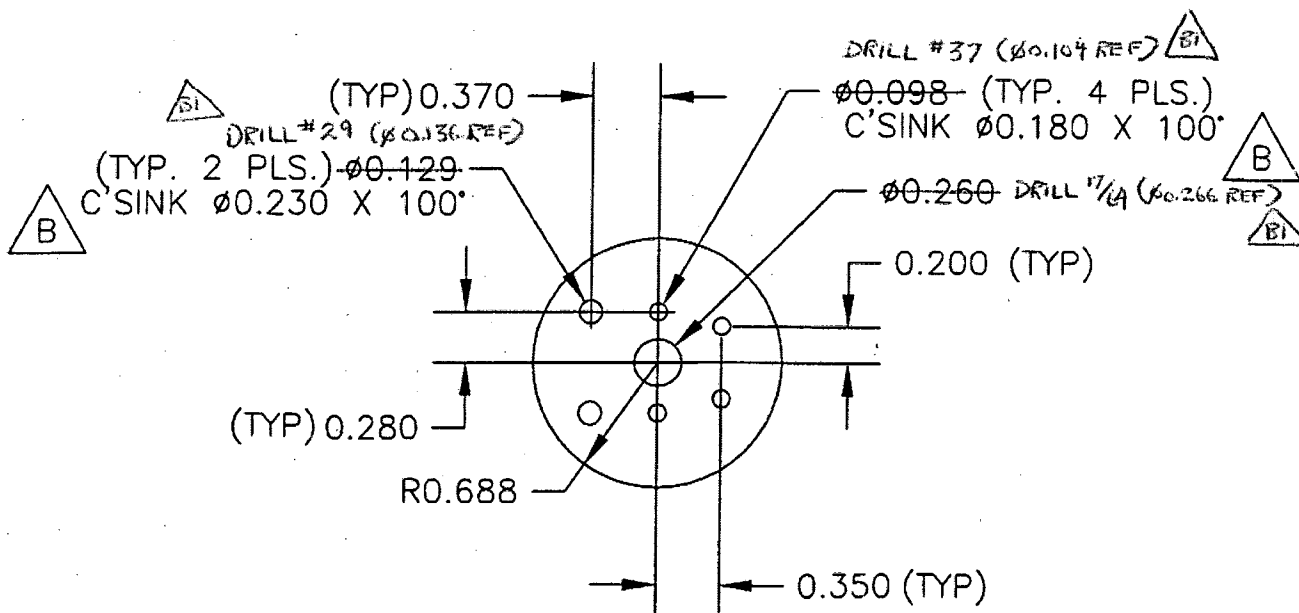
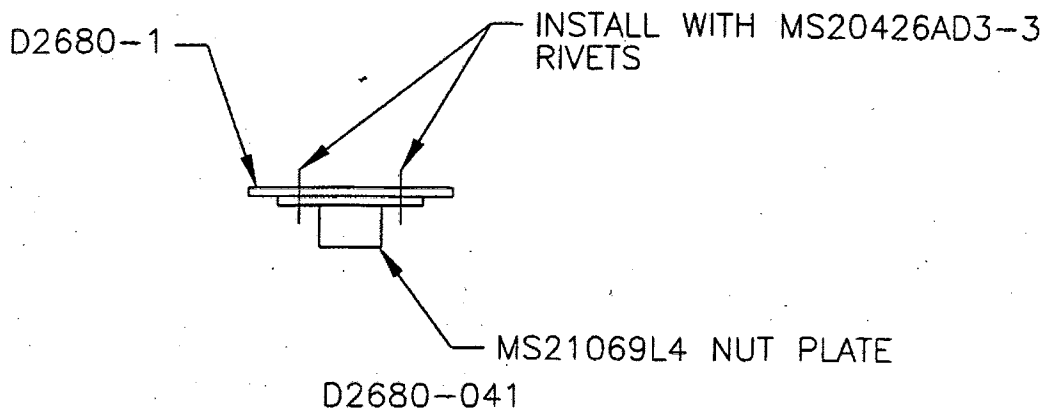
NOTE: Date & initial all entries

DART



DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE		SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS. (PER TSR A1041)	
BI	CP-# 04.11.04	CHANGE HOLES & FINISH	

RELEASED
98.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

~~GAD PLATE PRIOR TO INSTALLATION OF MS21069L4~~

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

\triangle BI POWDER COAT WHITE (4.35.2) PER DART QSI 005 4.3
D2680-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44086

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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